



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3913-041
Job Sheet 180535

Accounting Job RD18-607-01



POSITIVE
RECALL

Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Job Created: 7/9/18

Due Date: 7/16/18

Type: R+D

Status: Scheduled RELEASED **POSITIVE RECALL** AUTH 21 9-89

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/16/18	7/16/18	0.00	0.00	Start Up Large Fab-5		D.M.L 18-7-23
100	Large Fab	1 pcs	7/16/18	7/16/18	0.00	10.00	Large Fab 1		18-8-13 PTO
110	QC	1 pcs	7/16/18	7/16/18	0.00	0.00	QC9		12
120	QC	1 pcs	7/16/18	7/16/18	0.00	0.00	QC5		12
125	HandFinish	1 pcs	7/16/18	7/16/18	0.00	0.29	HandFinish2		
130	Powdercoat	1 pcs	7/16/18	7/16/18	0.00	0.93	Powdercoat2	N/A	DAS 21 9-89
140	QC	1 pcs	7/16/18	7/16/18	0.00	0.00	QC3		
150	HandFinish	1 pcs	7/16/18	7/16/18	0.00	0.50	HandFinish4		
160	QC	1 pcs	7/16/18	7/16/18	0.00	0.00	QC5		D 18-08-14
170	Packaging	1 pcs	7/16/18	7/16/18	0.00	0.00	Packaging3-2		BEB 18-08-14
180	QC21-SA	1 Ea	7/16/18	7/16/18	0.00	0.00	QC21		21 AUG 14 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg

~~130 - 1 Plug holes and mask only interior of hinge (3) prior to powder coat~~

150 - Pick Kit

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5078989
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5082948
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5093386
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5080994
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5079285
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5084677
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5089003
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	509168
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5083477
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5091248
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5079285
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5083610
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5070373

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐			
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 Ea (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish

5090771
 5090767
 5054916
 5050544
 5089298-1
 5086435
 5076007-1
 5078253
 5071415-1
 5084564

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	65	0
	D3913-1	1	6	0
	D3913-15	1	6	0
	D3913-3	1	7	0
	D3913-7	2	12	0
	D3913-9	1	11	0
	D3916-041	2	20	0
	D3916-5	3	19	0
	D4016-1	3	40	0
	D4017-7	3	39	0
	D4017-9	2	10	0
	D4020-11	2	21	0
	D4021-1	3	63	0
	D4034-041	1	1	0
	D4034-043	1	6	0
	D4672-1	2	26	0
	M304EX0.75-16F	33	903	0
150-HandFinish	AN3-10A	6	329	0
	D2931	2	996	0
	D4021-5	2	45	0
	MS20600-AD4W3	2	269	0
	MS21042L3	6	2,056	0
	NAS1149F0332P	12	1,369	0

NAS1149DN832J
 S034411

x2

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

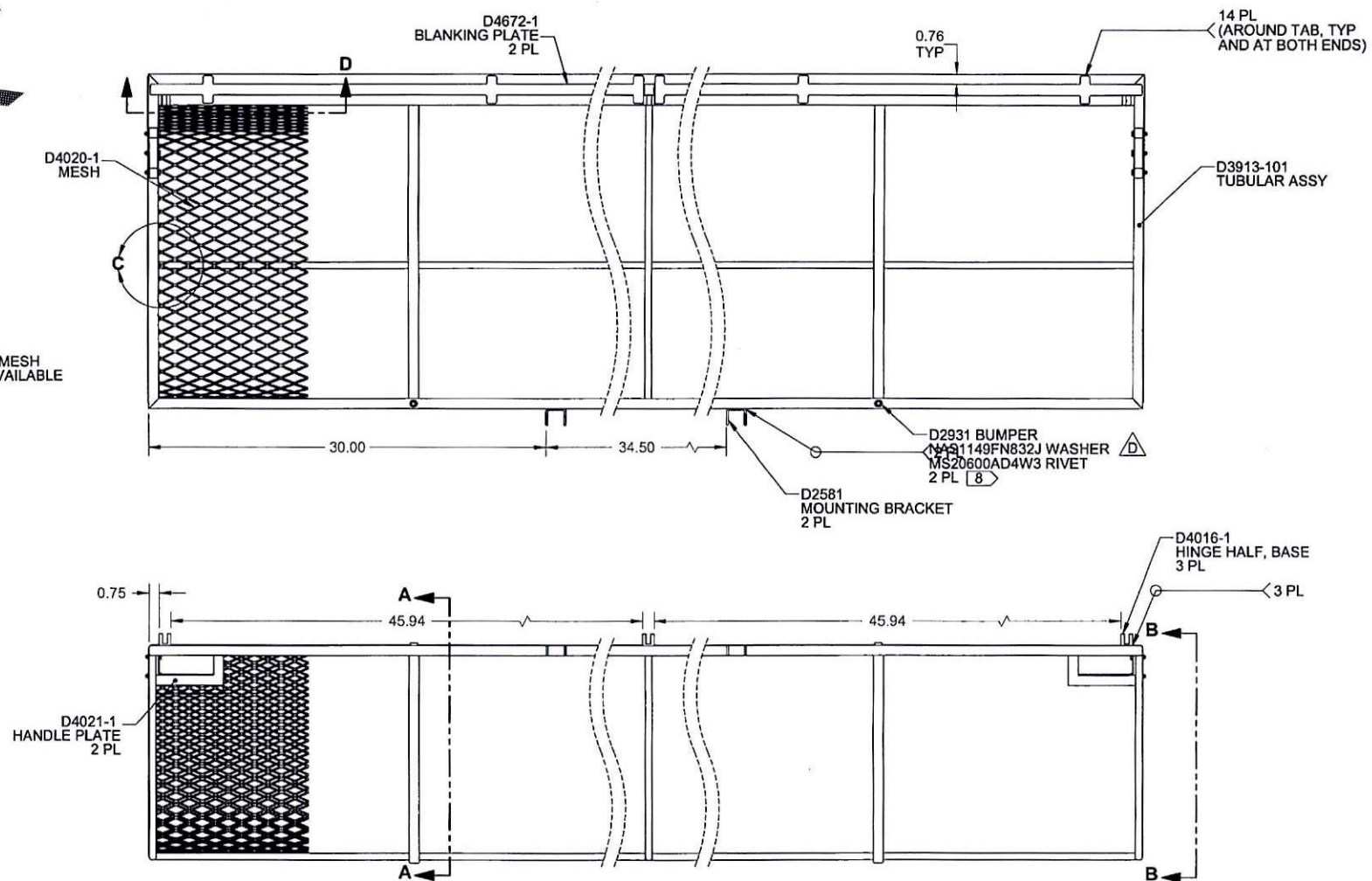
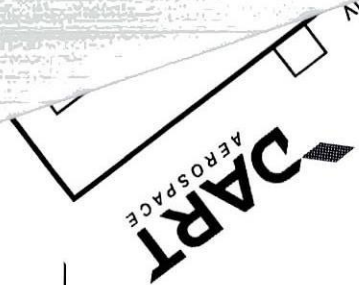


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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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OTHER : ☐					



TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C
SCALE: 2X

D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2017-06-07

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3913	SHEET 2 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET BASE ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

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WORK ORDER NON-CONFORMANCE / UPDATE

 QA Closed: **DAS 53**
 9-89
Date: **DEC 13 2018**Work Order update only ☐

Work Order: 180535 Part No. U 3913-041 NCR No. 18-7037	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☒ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : 18-08-01	Step #: 100	QTY Effective : ①		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		PD 18-08-01 Completed By  R-08-01 Lead hand / Supervisor Approval Verification PD 18-08-14 QC / QA Coordinator Approval PD 18-08-01	
During Fabrication of D3913-041 for the D5673-043, welder notice that one of the rib was not welded at the right place.		Cut weld on the rib and handle plate and then reposition the rib to drawing and weld MRB approval from Harwey is attach			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☒ Offset/Set up ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ ☒ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence			
		OTHER : _____			

Patrick Duval

From: Patrick Duval
Sent: Tuesday, July 31, 2018 2:53 PM
To: Harvey Siemens
Cc: Eric Downing; David Duval
Subject: RE: RD18-607-01, D5673 basket

Good, I will document the rework and attach this email to the work order.
And yes, the mesh has not been welded.

Pat Duval

From: Harvey Siemens
Sent: Tuesday, July 31, 2018 1:37 PM
To: Patrick Duval <pduval@dartaero.com>
Cc: Eric Downing <edowning@dartaero.com>; David Duval <dduval@dartaero.com>
Subject: RE: RD18-607-01, D5673 basket

Pat,

Makes complete sense to me, particularly if the mesh has not yet been welded.

HS

From: Patrick Duval
Sent: Tuesday, July 31, 2018 9:51 AM
To: Harvey Siemens <hsiemens@dartaero.com>
Cc: Eric Downing <edowning@dartaero.com>; David Duval <dduval@dartaero.com>
Subject: RD18-607-01, D5673 basket

Hi Harvey,
During fabrication of D3913-041 for the D5673-043, welder notice that one of the rib was not welded at the right place, (see photo 1, rib is supposed to be slush on the outside).
I would like to know if it's possible to cut the weld on the rib and the handle plate (see photo 2), and then reposition the rib to drawing on weld.

Pat Duval
QC Coordinator

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